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D4354-041
Job Sheet 188047



Part No: D4354-041

Job Qty: 6 ea

Part Name: Bearpaw Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/2/19

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV A 11.04.11 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		1/4/19	0.07	1.53	Waterjet - Flow		Sc 19/02/13
110	QC 2	6 pcs		1/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		Sc 19/02/13
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
120	QC 8			1/4/19	0.00	0.00	QC 8 - 12		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ ishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date : _____			MRB (QSI042) _____ Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____
Container No: S153231 Part: D4354 - 041 Job No: 188047 Serial No/Batch: S153231 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 02/13/19		STORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		Other/Details: _____ _____ _____	

	6 pcs					QC 8 - 14 QC 8 - 17 QC 8 - 20 QC 8 - 25 QC 8 - 3 QC 8 - 32 QC 8 - 33 QC 8 - 35 QC 8 - 38 QC 8 - 39 QC 8 - 4 QC 8 - 44 QC 8 - 45 QC 8 - 49 QC 8 - 58 QC 8 - 8 QC 8 - 9 QC 8 - 68 QC 8 - 67 QC 8 - 1 (A)	
130 Large Fab - Welded Assy-2-B4B	6 pcs	1/4/19	0.00	14.29		Large Fab - 1 - B4B Large Fab - 10 - B4B Large Fab - 2 - B4B Large Fab - 3 - B4B Large Fab - 4 - B4B Large Fab - 5 - B4B Large Fab - 6 - B4B Large Fab - 7 - B4B Large Fab - 8 - B4B Large Fab - 9 - B4B	DAS 40 9-89 DAS 9 9-89 19/02/25 
140 QC 5	6 pcs	1/4/19	0.00	0.00		QC 5 - 10 QC 5 - 12 QC 5 - 17 QC 5 - 18 QC 5 - 19 QC 5 - 22 QC 5 - 24 QC 5 - 3 QC 5 - 38 QC 5 - 42 QC 5 - 43 QC 5 - 49 QC 5 - 51 QC 5 - 58 QC 5 - 68 QC 5 - 9 QC 5 - 50 QC 5 - 30	
150 QC 9	6 pcs	1/4/19	0.00	0.00		QC 9 - 10 QC 9 - 18 QC 9 - 24 QC 9 - 43 QC 9 - 50 QC 9 - 9	
160 Packaging 3-1 - Stock - B4B	6 pcs	1/4/19	0.00	0.00			
170 QC21-SA	6 Ea	1/4/19	0.00	0.00		QC21	DAS 21 9-89  MAR 28 2019
Part Op 100 - 1-Cut as per Dwg (D4354-1) Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check)							

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

130 - (Weld per dwg A/R S.S. rod Batch: _____) 1- Weld cups as per dwg A/R S.S. ROD BATCH: 136585 2-
 Apply hardfacing on wearplate as indicated on dwg A/R HARDCOAT 2059B BATCH: 130145
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (QC9- Inspect visual per QSI004- Fusion Welds)
 160 - (Identify as per dwg & Stock Location: _____)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	5.5338 sf (.9223 ea)	100-Waterjet - Flow - 1	<u>5152146</u>
D4379-1	Wearplate Cup	60 Ea (10 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5140599</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	6	116	0
130-Large Fab - Welded Assy-2- B4B	D4379-1	60	18	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY Other/Details: _____			

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>SL</i>		Audited by: <i>40</i>		Preliminary Approval:	
Date: <i>19/02/13</i>		Date: <i>19/02/25</i>		Date:	

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	<i>[Signature]</i>

P/O D4354-041